Work Orde October-19-12 2	er ID 91930 2:33:42 PM		*(91930)*						Page 1
Revision ID:	D350-567-117		Accept			<u>040</u>	100)* s	Setup Sta	17	S1*
Start Date: Required Date:	Floor Window Installation, Extra Lar 10/22/12 Start Qty: 1.00 11/09/12 Req'd Qty: 1.00	*1* *1*			Cust Item Customer:	ID:				* *N	S2*
Reference: Approvals:	Process Plan:QC:					Date:			Run Sta Sto	" \	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set U Run	p/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr			<u></u>							
IIN-D350-567	Rev D	<i>D</i>		DAS)							
*100 *100* DC Document Control	DOCUMENT CONTRO Memo Photocopy	DL SM bluefile and type labels as p	0.00 0.00 per PPP D350-	19-11-01							
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Quality Control

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NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
											QA Closed:	Dat	.e:	·
						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
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Part N	مام					Scrap	1 1		⊢	Small Fab	Pro	d. Eng. Coor.	\dashv	Quality
raiti	١٠.				 	Use-as-is	1		noforming	Finishing	1	re/Packaging	\dashv	Other
NCR I	No.					Work Order Update	1		· —	Composite	·	Supplier	ᅱ	
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Root					Descri	ption of work order update		Initial	Action	1	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descripti	ion	Date	Verification	<u> </u>	QC Inspector
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Equip/Tooling							l							
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	-	Bending				Bend	-	Grain		ļ	Ovalized		\vdash	Pressure/Forced
						BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under		\vdash	Temperature/Cure
	\vdash	Cracks			<u> </u>	Broken/Damaged	-	-1 '	ion Incomplete		Part Incorre		\vdash	Weld
	-	Crushed/	Crimped.	-	<u> </u>	Burrs		4	tions Incomplete/Unc	lear	Part Lost/M	-	<u> </u>	Wrong Stock Pulled
	\vdash	Cuffs				Contamination	<u> </u>	Mainte		Part Moved				
	\vdash	Heat Trea				Countersink	<u> • </u>	Mislabe		ļ	Positioned Wrong			1
		Inspection	n Strip in	Tube		Cut Too Short	L	Misread	ť		Power Loss,	/Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

Work Order ID 91930 Page 2 October-19-12 2:33:42 PM D350-567-117 Item ID: Accept *N900040100* Setup Start Revision ID: Item Name: Floor Window Installation, Extra Large Start Oty: 1.00 **Start Date:** 10/22/12 **Cust Item ID:** Required Date: 11/09/12 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: Date: **Tooling:** Approvals: Date: Stop SPC (Y/N): QC: Date: Date: Sequence ID/ Operation Tool ID Tool # Plan Accept Reject Reject Set Up/ Insp. **Work Center ID** Code Qty Otv Number Stamp Description **Run Hours** 130 0.00 Packaging *130* Packaging 0.00 Memo Identify and pack for shipping as per PPP D350-567-117 Packaging Location: QC21- Final Inspection - Work Order Release 0.00 140 *140*

0.00

Memo

Quality Control

MC2 12-11-01

NCR: Y																	
											QA Closed:	Date:					
Work Orde	er:					DISPOSITION			AGAINST DEPARTMENT/PROCESS								
***************************************	•					Rework			Skid-tube	Crosstube		Water Jet	Engineering				
Part N	۱o.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality				
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Root					ı	ption of work order update		nitial	1	tion	Sign &						
Cause		Date	Step	Qty	·	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector				
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	_	Cracks				Broken/Damaged		Inspection Incomplete			Part Incorrect		Weld				
		Crushed/	Crimped.		-	Burrs	<u> </u>	1	tions Incomplete/	Unclear	Part Lost/Missing		Wrong Stock Pulled				
,	_	Cuffs			-	Contamination	<u></u>	Mainte		<u> </u>	Part Moved	• • • • • •					
	-	Heat Trea			-	Countersink	-	Mislabe		ļ	Positioned V		٦٥٠٠				
		Inspection		Tube	<u> </u>	Cut Too Short	—	Misrea	đ	L	Power Loss/	Surge	Other				
	<u> </u>	Ripples in			_	Drill Holes	\vdash	Offset									
	<u> </u>	Torque W			n	Drawing	-	ł	Calibration								
	Turning Sequence Finish						L	JOut of :	Sequence								

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

October-19-12 2:33:42 PM

Page 1

Work Order ID:

91930

Parent Item:

D350-567-117

Parent Item Name:

Floor Window Installation, Extra Large

Start Date: 10/22/12

Required Date: 11/09/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A

08.09.30 new issue EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-567-031 Interior Floor Window (SI	SW) iding Door Compatible)	Manufactured	No			110	Each	0.0000	The second second	1884	AB		
D350-567-1-13 Replacement Window, Ex	SWZ	Manufactured	No			110	Each	2.0000	0 9	2478	1 B		2//0/3
,	Ü			Location		Loc Oty	Lo	c Code					

FG042

88810

2 2

DQA: Date:

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	:					
Work Ordei	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part N	0.				Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other					
Doot.			T 1	Doscri	ption of work order update	Initial	1 0	tion	Sign &							
Root Cause	Date	Step	Qty		or Non-conformance	Chief Eng		ription	Date	Verification	QC Inspector					
	Date	step	Qty		or Non-comormance	Cilier Eng	Desc.	ription	Date	vermeation	Qe irispector					
Doc/Data	-						1									
quip/Tooling Operator	\dashv															
Material	-															
Setup																
Other	-															
Process		İ														
Supplier	\dashv															
Training																
Jnapproved	-					1										
1	l	<u>i</u>	J		F	AULT CAT	EGORY		1	L						
Landin	g Gear				General											
Γ	Bending				Bend	Grain			Ovalized	Γ	Pressure/Forced					
F	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hardw	are are		Over/Under	tolerance	Temperature/Cure					
	Cracks	-				Inspec	tion Incomplete		Part Incorrect		Weld					
	Crushed/	Crushed/Crimped Burrs				Instru	ctions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled					
	Cuffs Contamination				Main	tenance		Part Moved								
	Heat Trea	Heat Treat Countersink				Mislak	peled		Positioned V	Vrong						
	Inspectio	Inspection Strip in Tube Cut Too Short				Misre	ad		Power Loss/	Other						
	Ripples in	n Bend			Drill Holes	Offset	Offset									
	Torque W	Vaves in E	xtrusio	1	Drawing	Out of	Out of Calibration									
Ţ	Turning S	equence			Finish	Out of	Sequence									
	Wave/Tw	ist in Tul	oe		Folio	Outsid	le Dimensions									